

**Work Order ID 85001**

May-31-12 9:09:39 AM

**\*85001\***

Page 1

Item ID: D212-725-1-111

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: ENGINE MOUNT DECK FITTING

Start Date: 5/31/12 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 5/31/12 Req'd Qty: 2.00

**\*2\***

Customer:

Reference: rework to new rev

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D4231

A U/R

105

0.00

**\*105\***

Mill Conv

Memo

0.00

Conventional Milling Machine

PULL FROM STK:

2 X D212-725-1-111 B45608

REWORK/MILL PER NEW REV.

120

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*120\***

QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00

**\*130\***

QC

Memo

0.00

Quality Control

Crushed  
parts will  
be found per  
JL

W  
120710

May-31-12 9:09:39 AM

**Item ID:** D212-725-1-111

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

**Revision ID:**

Stop \*NS2\*

**Item Name:** ENGINE MOUNT DECK FITTING

**Start Date:** 5/31/12      **Start Qty:** 2.00      **\*2\***

**Cust Item ID:**

**Required Date:** 5/31/12      **Req'd Qty:** 2.00      **\*2\***

**Customer:**

**Reference:** rework to new rev

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

OC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140

Outsource process-Cadplate per QSI017 4.1.9.1

0.00

**\*140\***

Outsource3

## Memo

0.00

Outsource process - Cad plate

Issue P/O: \_\_\_\_\_ Cad Plate per QQ-P-416F Class I Type  
IIConformity sheet required

150

Receive & Inspect for Damage & Mat'l Certs

0.00

**\*150\***

### Packaging

## Memo

0.00

## Packaging

Ensure certificate of conformity is attached

160

QC3- Inspect Part Finish

0.00

**\*160\***

QC

## Memo

0.00

### Quality Control

May-31-12 9:09:39 AM

**Item ID:** D212-725-1-111

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

**Item Name:** ENGINE MOUNT DECK FITTING

**Start Date:** 5/31/12      **Start Qty:** 2.00      **\*2\***

**Cust Item ID:**

**Required Date:** 5/31/12      **Req'd Qty:** 2.00      **\*2\***

**Customer:**

**Reference:** rework to new rev

Run Start \*NR1\*

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Stop **\*NR2\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

### Operation Description

### Set Up/ Run Hours

[illegible]

170

Identify as per dwg &amp; Stock Location:\_\_\_\_\_

0.00

**\*170\***

## Packaging

## Memo

0.00

## Packaging

180

OC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

## Memo

0.00

### Quality Control

# Picklist Print

May-31-12 9:09:39 AM

Page 1

Work Order ID: 85001

Parent Item: D212-725-1-111

Start Date: 5/31/12

Required Date: 5/31/12

Parent Item Name: ENGINE MOUNT DECK FITTING

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 06-12-19 JLM  
IPP Rev:B Added Cad Plating 07-07-23 Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D212-725-1-111 ENGINE MOUNT DECK FITTING		Manufactured	No				Each	0.0000		2			

## Linda Lacelle

---

**From:** Jean-Luc Menard <jmenard@dartaero.com>  
**Sent:** May-30-12 1:41 PM  
**To:** 'Linda Lacelle'  
**Subject:** RE: D212-725-1-109/-110/-111 Engine mounts for Eagle Single

Conv milling      mill as per new rev  
Qc2  
Qc8  
I think we will have to re cad plate.

85001

JL

---

**From:** Linda Lacelle [mailto:llacelle@dartaero.com]  
**Sent:** Wednesday, May 30, 2012 12:56 PM  
**To:** 'Jean-Luc Menard'  
**Subject:** RE: D212-725-1-109/-110/-111 Engine mounts for Eagle Single

- 45608

Will you take them out of stk pls, write up what has to be done, and I'll make the w/o from that..  
Thx  
L

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**From:** Jean-Luc Menard [mailto:jmenard@dartaero.com]  
**Sent:** May-30-12 12:53 PM  
**To:** 'Linda Lacelle'; 'Roberto Fuentes'  
**Cc:** 'Eric Downing'; 'David Shepherd'; 'Mike Petsche'; 'David Shepherd'; 'Kim Johnston'  
**Subject:** RE: D212-725-1-109/-110/-111 Engine mounts for Eagle Single

Yes we will be able to re-work them.  
JLM

---

**From:** Linda Lacelle [mailto:llacelle@dartaero.com]  
**Sent:** Wednesday, May 30, 2012 6:10 AM  
**To:** 'Roberto Fuentes'; 'Jean-Luc Menard '  
**Cc:** 'Eric Downing'; 'David Shepherd'; 'Mike Petsche'; 'David Shepherd'; 'Kim Johnston'  
**Subject:** RE: D212-725-1-109/-110/-111 Engine mounts for Eagle Single

Only 2 x D212-725-1-111 in stk...JL can you let me know if these can be reworked..  
L

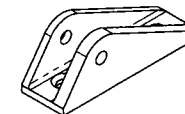
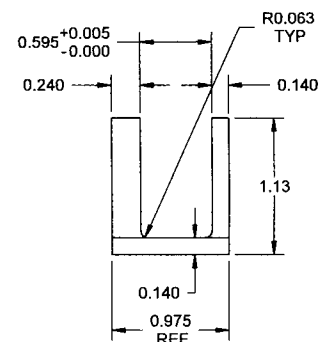
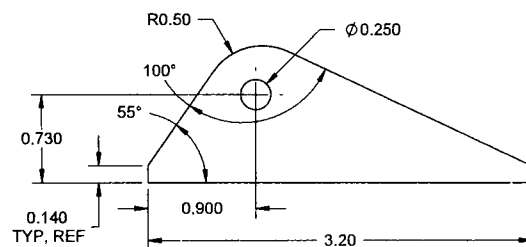
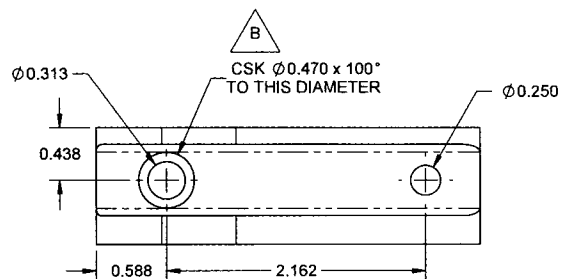
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**From:** Roberto Fuentes [mailto:rfuentes@dartaero.com]  
**Sent:** May-29-12 6:47 PM  
**To:** Linda Lacelle  
**Cc:** Jean-Luc Menard ; Eric Downing; David Shepherd; Mike Petsche; David Shepherd; Kim Johnston  
**Subject:** D212-725-1-109/-110/-111 Engine mounts for Eagle Single

Hi Linda,

I just posted D4231-PB2 engine mount drawing for review and approve by production. If there is any W/O in progress need to be updated per this new drawing and check the stock. I just got the feedback from Eagle today.

Thanks,  
Roberto



*also 85007*

# NOTES:

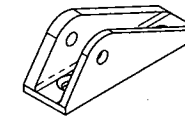
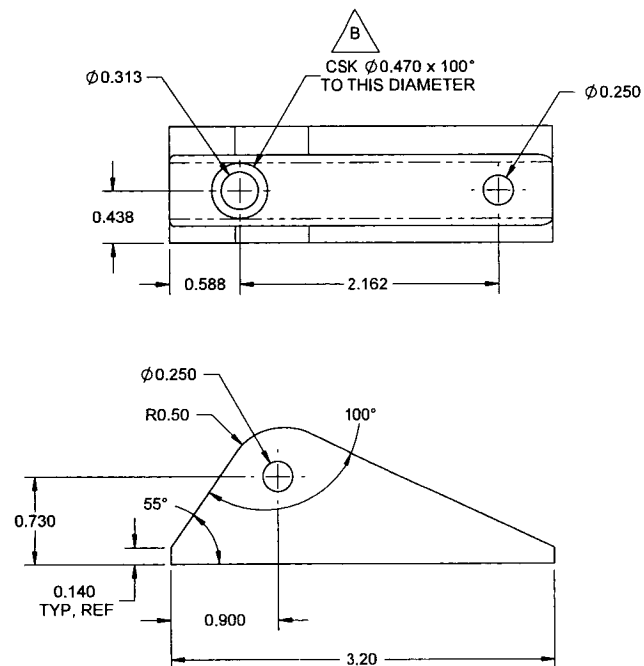
- 1) MATERIAL: AISI 4140 STEEL BAR  
PER MIL-S-5626 OR AMS 6382/6349/6529  
REF DART SPEC. M4140N-B  
OR AISI 4130 STEEL BAR  
PER MIL-S-6758 OR AMS 6345/6348/6370/6528  
REF DART SPEC. M4130N-B  
HEAT TREAT TO MIN. ULTIMATE TENSILE STRENGTH = 125 ksi
- 2) FINISH: CADMIUM PLATE PER AMS-QQ-P-416B, CLASS I, TYPE II
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.30 lbs

## **D212-725-1-109 SMALL ENGINE MOUNT, LH**

## **PRELIMINARY ISSUE**

**12.05.29**

PB2	CSK Ø0.470 x 100° WAS Ø0.446 x 45° CHAMFER (ZN D5-1, D5-2)	RF	12.05.29
A	NEW ISSUE	RF	11.02.24
REV.	DESCRIPTION	BY	DATE
DESIGN	JL	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. PB2
MFG. APPR.		D4231	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		ENGINE MOUNT	NTS
DATE	12.05.29	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



# **D212-725-1-110 SMALL ENGINE MOUNT, RH**

**PRELIMINARY ISSUE**

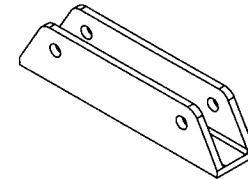
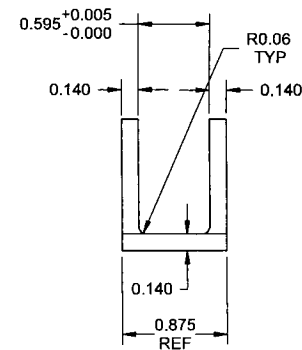
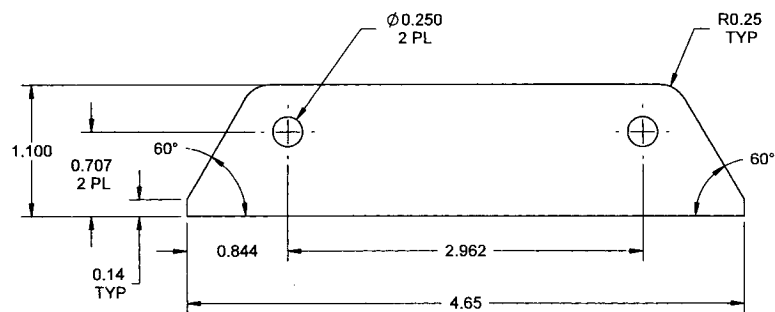
**12.05.29**

## **NOTES:**

- 1) MATERIAL: AISI 4140 STEEL BAR  
PER MIL-S-5626 OR AMS 6382/6349/6529  
REF DART SPEC. M4140N-B  
OR AISI 4130 STEEL BAR  
PER MIL-S-6758 OR AMS 6345/6348/6370/6528  
REF DART SPEC. M4130N-B  
HEAT TREAT TO MIN. ULTIMATE TENSILE STRENGTH = 125 ksi
- 2) FINISH: CADMIUM PLATE PER AMS-QQ-P-416B, CLASS I, TYPE II
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.30 lbs

DESIGN	JL	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>RF</i>	DRAWING NO. <b>D4231</b>	REV. PB2
MFG. APPR.			SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>ENGINE MOUNT</b>	NTS
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# **D212-725-1-111 LARGE ENGINE MOUNT**

## **NOTES:**

- 1) MATERIAL: AISI 4140 STEEL BAR  
PER MIL-S-5626 OR AMS 6382/6349/6529  
REF DART SPEC. M4140N-B  
OR AISI 4130 STEEL BAR  
PER MIL-S-6758 OR AMS 6345/6348/6370/6528  
REF DART SPEC. M4130N-B  
HEAT TREAT TO MIN. ULTIMATE TENSILE STRENGTH = 125 ksi
- 2) FINISH: CADMIUM PLATE PER AMS-QQ-P-416B, CLASS I, TYPE II
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.47 lbs

## **PRELIMINARY ISSUE**

12.05.29

DESIGN	JL	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO. <b>D4231</b>	REV. PB2
MFG. APPR.			SHEET 3 OF 3
APPROVED		TITLE <b>ENGINE MOUNT</b>	SCALE NTS
DE APPR.		<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DATE	12.05.29		